

Date: Thursday, 20/11/2008 7:45:06 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TOP PANNEL ASS'Y
Job Number :	43562		
Estimate Number :	13067		
P.O. Number :		Part Number :	D3650041
This Issue :	20/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3650 REV.C
First Issue :	1/1	Project Number :	N/A
Previous Run :	42039	Drawing Revision :	C
	Type :	Material :	
	SMALL /MED FAB	Due Date :	27/11/2008
Written By :		Qty:	3
Checked & Approved By :	<u>MF 08-11-20</u>	Um:	Each
Comment :	Est Rev:A New Issue 07-11-12 EC verified by: DD Est Rev:B Ecn 1113P 08-01-22 DD verified by:EC Est Rev:C Ecn1162 08-04-02 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 pick kit

2.0	D36501	Aft Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 AFT PANEL
 batch B42094

SB 08/11/20 (3)

3.0	D36503	Center Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 CENTER PANEL
 batch B42095

SB 08/11/20 (3)

4.0	D36505	Fwd Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 CENTER PANEL
 batch B42096

SB 08/11/20 (3)

5.0	AN3C3A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)
 Bolt
 batch M109371

SB 08/11/20 (3)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANNEL ASS'Y

Job Number: 43562

Part Number: D3650041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 8.0000 EACH(s)/Unit Total: 24.0000 EACH(s)

WASHER

batch M109148

SB 08/11/20 (3)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3650

2- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealant
as per dwg D3650

Batch: 17109536

FF 08/11/20 3

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/20 (x3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: CA

SB 08/11/20 (3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

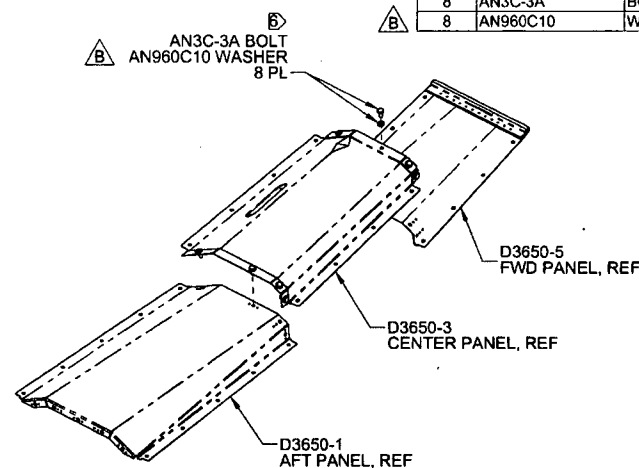
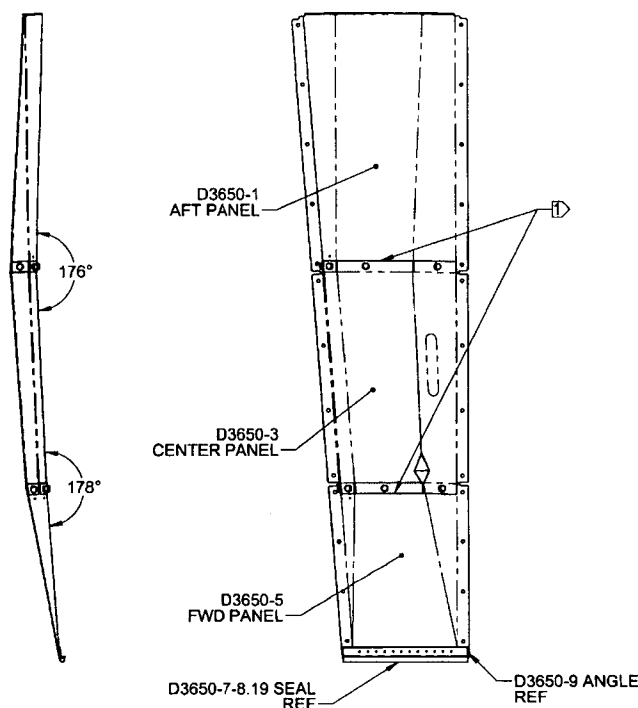
08/11/26

Job Completion



MF 08-11-25

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



RELEASED
11.17.14

D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4MS WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/11F FROM SHEET 6; UPDATED DIMS OF D3650-11/11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3650		REV. C SHEET 1 OF 9	
TITLE TOP PANEL ASSEMBLY		SCALE 1:8	
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43562